

Work Order ID 69864

Friday, May 20, 2011 10:42:47 AM



Page 1

Item ID: D4038-1

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, LH

Stop



Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/05/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

D0/R

0.00

100



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.125" long

0.00

110



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: *E*

Folio Rev: *AA*

Deburr

CL 11/06/07

2 0

SL 11/06/08

2

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/06/08

2

0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

B.A 11/06/08

2

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

2X 0 m.d 11/06/08



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D4038-1

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Setup Start



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Stop



Item Name: Angle, Fwd, LH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

2 0 11/06/09

160 Identify as per dwg & Stock Location: GA

0.00



Packaging Memo

0.00

Packaging

w/o
69861

ES 11/06/09 (2x)

170 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/6/09

MF
11-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 10:42:45 AM

Page 1

Work Order ID: 69864



Parent Item: D4038-1



Parent Item Name: Angle, Fwd, LH

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	21.2845	0.6	1.263158			
6061T6 ANGLE 4.00 x 4.00 x .250													

Location

Loc Qty

Loc Code

MAT006

20

117285

20

MAT007

1.2845

114507

1.2845

1.263

on 5/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69864
Description: Angle Fwd, LH		Part Number: D4038-1
Inspection Dwg: D4038	Rev: E	Page 1 of 1

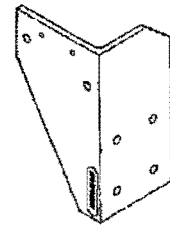
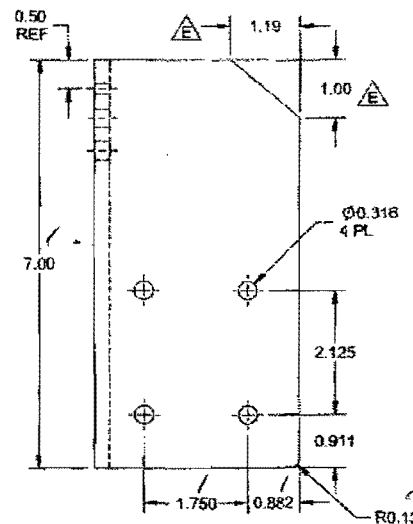
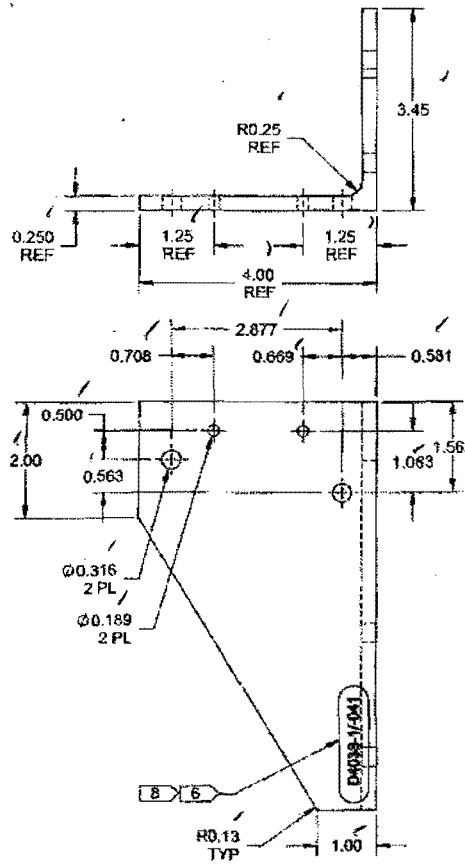
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+ .030	3.452	✓		VERN. J-3	
1.25	+ .030	1.249	✓		"	
4.00	+ .030	3.995	✓		"	
1.25	+ .030	1.245	✓		"	
1.25	+ .030	.250	✓		R-G	
.250	+ .010	.246	✓		"	
2.877	+ .010	2.877	✓		H-G	
.581	+ .010	.581	✓		"	
.669	+ .010	.669	✓		H-G	
.708	+ .010	.708	✓		H-G	
.500	+ .010	.500	✓		H-G	
2.00	+ .030	2.00	✓		"	
.563	+ .010	.563	✓		H-G	
Ø.316	+ .006 - .001	.316	✓		"	
Ø.189	+ .005 - .001	.189	✓		"	
1.13	+ .030	1.130	✓			
1.00	+ .030	.990	✓		"	
1.063	+ .010	1.063	✓		H-G	
1.563	+ .010	1.563	✓		"	
.50	+ .030	.50	✓		"	
7.00	+ .030	7.001	✓		VERN. CNC-02	
1.750	+ .010	1.750	✓		"	
.882	+ .010	.882	✓		"	

Measured by: <u> </u>	Audited by: <u>B.A.</u>	Prototype Approval: <u> </u>
Date: <u>11/06/08</u>	Date: <u>11/06/08</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4038-1 ANGLE, FWD, LH

69864

RELEASED
2011-04-21

- NOTES:
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 1.03 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 3 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	<small> COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES OF THE PROJECT ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	

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-158

